

CLAIM AMENDMENT

1. A method for forming a bond, in a heat transfer device, between a tube and a header having a generally circular opening having a first predetermined diameter formed on a first side thereof for receiving one end of said tube, said method comprising the steps of:

- a) providing at least one generally circular end having a second predetermined diameter on said tube to fit into said generally circular opening of said header;
- b) inserting said one end of said tube into said first side of said header; and
- c) forming a bond between said one end of said tube and said header.

2. The method of claim 1 wherein said tube is a coolant tube having a generally oblong cross section.

3. The method of claim 1 wherein said header contains a plurality of generally circular openings.

4. The method of claim 1 wherein said heat exchanger includes one of a CT and a Serpentine fin core.

5. A method for forming a bond between a coolant tube having a generally oblong cross-section and a header member of a heat exchange device, said header member having a predetermined plurality of generally circular openings, having a first predetermined diameter, formed therein in one of a CT and a serpentine fin configuration, said method comprising the steps of:

- a) shaping one end of said tube to change said generally oblong cross-section of said tube at said one end into a generally circular cross section having a second predetermined diameter;
- b) inserting said one end of said tube into one of said predetermined plurality of generally circular openings formed in said header member on a first side thereof; and
- c) forming a bond between said one end of said tube and said header member.

6. The method of claim 5 wherein step (c) includes forming said bond mechanically.

7. The method of claim 6 wherein said bond is formed mechanically by rolling said tube into said generally circular opening in said header member.

8. The method of claim 5 wherein step (b) includes inserting said one end of said tube into said one of said predetermined plurality of generally circular openings formed in said header member until it extends at least through a thickness of said header member.

9. The method of claim 8 wherein said method includes the additional step of removing any excess portion of said tube which extends above a second side of said header member after step (c).

10. The method of Claim 5 wherein step (a) includes the step of inserting an internal sizing tool having a generally circular cross section into said one end of said tube.

11. The method of claim 10 wherein step (a) includes the step of shaping an outer surface of said one end of said tube with an external sizing tool having a generally hollow circular cross section.

12. The method of claim 5 wherein said method includes the additional step of forming threads in a surface of each of said predetermined plurality of openings formed in said header member.

13. The method of claim 5 wherein said method further includes the step of forming said openings in said header member in a staggered arrangement.

14. The method of claim 5 wherein said method further includes the step of forming said openings in said header member in substantially parallel rows.

15. The method of claim 5 wherein said first predetermined diameter is slightly larger than said second predetermined diameter.

16. The method of claim 5 wherein step (a) includes using an adhesive in forming said bond.

17. - 20. (Cancelled)